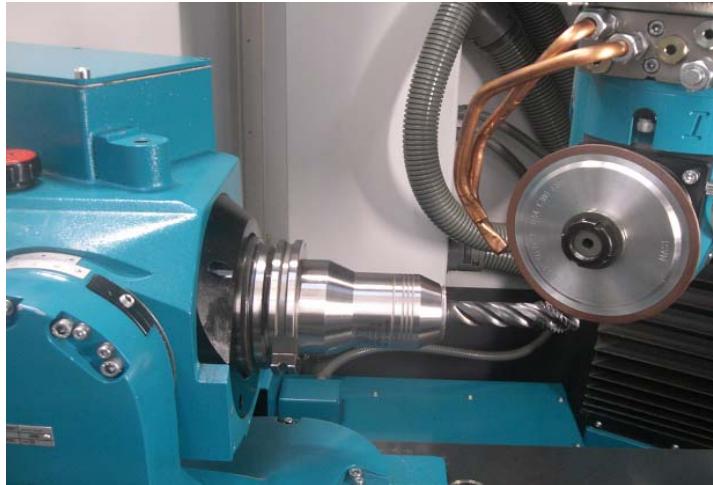


Tap M24

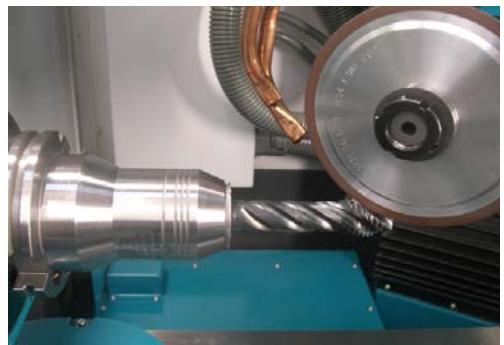
A10-010

Rake angle 8°, compromise for cutting speeds between 7 m/min (Inox 900) and 15 m/min (Steel 900).



1. Cycletime for Resharpening

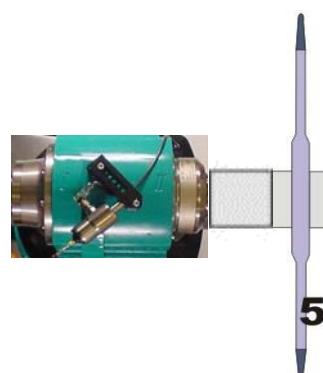
Tool specifications	
Diameter 24 mm, Z 4, Length of cutting edge 40 mm, Helix angle 45°	
Material HSS	
Operations	Probe Flute 1
Feed [mm/Min]	1 140
Power [kW]	2
Cutting feed [m/s]	18
Used wheels	5
Grinding time [s]	60 117
Total cycle time	2 Min 56



The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

5	14F1 Ø150 B126
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3. Machine and Software Requirements

Machines: 2 axes CNC grinders : ARIES ENP 2

Control: Fanuc 35i

Coolant: Synthetic Oil, pressure 3 bar

Software: Menu guided macro executer

responsible engineer: KCM, 16.09.09

www.schneeberger.ch

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

Subsidiaries in: France, Deutschland, Italia, United States, China

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